Work Order August-21-13 2:1		843		*10!	5843	*						Page 1
Revision ID:	03265-1 Rib			Accept	*N9	იიი	140	100)* s	etup Star Stop	I VI	S1* S2*
	3/21/13	Start Qty: 2.00 Req'd Qty: 2.00	*2* *2*		Cust l Custo	Item ID: omer:	:					. 7/
		: MUS	Date: <u>/3 -08 - 2 </u> Date:			_ Date	e:		R	tun Star Stop	, "IV	R1* R2*
Sequence ID/ Work Center ID		Operation Description		Set Up/ Run Hours	Tool	I ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revis	ion Nbr										
D3265	E		· · · · · · · · · · · · · · · · · · ·								·	
100 *100* Large Fab	1	Large Fab Memo		0.00						13:01	ક:એI	10_
Large Fab			65-1 rib as per dwg dentification markings	DAS 27								
*11 0 *11 0 * _{QC}	(QC5- Inspect part comp Memo	leteness to step on W/O	0.00 9-89 0.00 S.	3]				<u>_</u>			
Quality Control												
20 *120* Packaging	1	Identify as per dwg & St	tock Location: Wkoo'l	0.00						<u>R-089</u>	N	<u>PD</u>

Packaging

											DQA:	Date	: _
NCR: Y	⁄es	/ No				WORK ORDER NON-C	ON	FORN	AANCE / UPD	ATE			
						<u> </u>					QA Closed:	Date	:
Work Orde	or.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
WOIR OIG	-					Rework	1		Skid-tube	Crosstube		Water Jet	Engineering
Part N	No.					Scrap	1 1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	_		-			Use-as-is	1	Therm	oforming	Finishing	Rec/Stor	e/Packaging	Other
NCR N	No					Work Order Update	1		Large Fab	Composite		Supplier	
Root					Descri	ption of work order update	In	itial	Acti	on	Sign &	<u></u>	
Cause		Date	Step	Qty		or Non-conformance	Chie	ef Eng	Descri	iption	Date	Verification	QC Inspector
Doc/Data												1	
Equip/Tooling					i 							ı	
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Supplier) ,		,						1		
Training													
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						F/	AULT	CATE	GORY	<u> </u>			
Landi	ng G	ear				General					•	_	
		Bending				Bend	Цí	Grain			Ovalized	L	Pressure/Forced
		Centre No	ot Concer	ntric to	O/S	BOM/Route	LJ,	Hardwa	re		Over/Under	tolerance	Temperature/Cure
						Broken/Damaged	<u></u>	nspecti	on Incomplete		Part Incorred	ct	Weld
		Crushed/0	Crimped			Burrs	U	nstructi	ions Incomplete/U	nclear	Part Lost/Mi	ssing	Wrong Stock Pulled
		Cuffs				Contamination		Mainte	nance		Part Moved		
		Heat Trea	it			Countersink		Mislabe	led		Positioned V	Vrong	
	\square	nspection	n Strip in	Tube		Cut Too Short	Misread , Power Loss/Surge O					Other	
		Ripples in	Bend			Drill Holes	П	-					

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Orde August-21-13 2		05843		*105843*										
Item ID: Revision ID: Item Name:	D3265-1			Accept	*N900	040	100)*	Setup	Start Stop		S1* S2*		
Start Date: Required Date:	8/21/13 9/04/13	Start Qty: 2.00 Req'd Qty: 2.00	*2* *2*		Cust Item I Customer:	D:								
Reference:), o (, 13	104 0 2131 2.00	·· /·		Customer.									
Approvals:	Process Pl	an:	Date:	Tooling:	D:	ate:	- 	I	Run	Start	*N	R1*		
	QC:		Date:	_ SPC (Y/N):	D	ate:				Stop	*N	R2*		
Sequence ID/ Work Center II		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp		
130		QC21- Final Inspection -	Work Order Release	0.00										
130		Memo		0.00				M	<u> </u>	13-	580	7		

Quality Control

130831

NCR: \	R: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE QA Closed: Date:												
										···	QA Closed:	Date:	
Work Orde	er:					DISPOSITION				AGAINST DE	PARTMENT,	/PROCESS	
Part N	•					Rework Scrap			Skid-tube Machining	Crosstube Small Fab	1	Water Jet d. Eng. Coor.	Engineering Quality
NCR I	No.					Use-as-is Work Order Update]	Thern	noforming Large Fab	Finishing Composite	Rec/Sto	re/Packaging Supplier	Other
Root					Descri	ption of work order update		nitial	Act	ion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	QC Inspector
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المسال			<u>.</u>		<u>.</u>		AUL	T CATE	SURT				
Landi	ng c	Bending				General Bend		Grain			Ovalized		Pressure/Forced
	\vdash	Centre No	at Conco	atric to		BOM/Route		Hardwa	ro	—	Ovanzed Over/Under	tolerance	Temperature/Cure
		Cracks	or concer	iti ic to	^{0/3} ⊢	Broken/Damaged		ł	on Incomplete	-	Part Incorred	-	Weld
	\vdash	Ì	Crimned			Burrs	-	†	ions Incomplete/L	-	Part Lost/Mi	⊢	Wrong Stock Pulled
	Crushed/Crimped Cuffs					Contamination		Mainte	•	—	Part Moved		James Stock : alled
	\vdash	Heat Trea	nt		<u> </u>	Countersink		Mislabe		⊢	Positioned V	Vrong	
	一	Inspection		Tube		Cut Too Short	\vdash	Misread			Power Loss/	· ·	Other
}	Ripples in Bend Drill Holes							Offset		L	1	·	
		Torque W		xtrusio	n	Drawing	Out of Calibration						
		Turning S				Finish		Out of 9	equence				

Outside Dimensions

DQA:

Date:

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Wave/Twist in Tube

Picklist Print

August-21-13 2:16:33 PM

Work Order ID: 105843

105843

Parent Item: D3265-1 *D3265-1*

Parent Item Name: Rib

Start Date: 8/21/13

Required Date: 9/04/13

Page 1

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP REV:A 12.07.26 AS PER DWG REV.D DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status	
M304TS0.750W.065		Purchased	No			100	ſ	1,875.991	4.729	9.955789				
M304TS0	750W	იგ5							**			13.0B	<u>ال.</u>	PD

304 SQ Tube .75x.75x.065W

Location	Loc Oty	Loc Code	
MAT017	1572.176947		
123303	0.2049474		
125513)	971.972		(9.9
m126538	600		
WA006	303.81421		
125068	303.81421		

												DQA:	Da	ite:	
NCR:	/es	/ No				WORK ORDER NON-C	100	NFORM	ANCE / UP	DATE			-		
												QA Closed:	Da	ite:	
Work Orde	ar.					DISPOSITION				AGAINST [ÞΕ	PARTMENT,	/PROCESS		
WOIK OIG	-' <i>'</i> .					Rework	1		Skid-tube	Crosstube]	Water Jet		Engineering
Part f	۱o.					Scrap	1		Machining	Small Fab		Pro	d. Eng. Coor.	, 🗀	Quality
			_			Use-as-is	1		noforming	Finishing	<u> </u>				Other
NCR I	No.				i	Work Order Update			Large Fab	Composite	- - -				
						iption of work order update Initial Action				<u>-</u> .					,
Root						otion of work order update		Initial				Sign &			
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	ription		Date	Verification	<u>n</u>	QC Inspector
Doc/Data	_								}						
Equip/Tooling		•						i							
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Other			1	ļ			ł								
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						F.	ΑU	T CATE	GORY		_		 		
Landi	ng (ear				General	_	,		_		•		_	1
		Bending				Bend		Grain		1	_	Ovalized		igspace	Pressure/Forced
		Centre No	ot Concer	ntric to	o/s	BOM/Route		Hardwa	re	L		Over/Under	tolerance		Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	ion Incomplete	Ĺ	_	Part Incorred	ct	L	Weld
		Crushed/	Crimped			Burrs	L	Instruct	ions Incomplete/	Unclear		Part Lost/Mi	ssing		Wrong Stock Pulled
		Cuffs				Contamination		Mainte	nance			Part Moved			
		Heat Trea	ıt			Countersink		Mislabe	led	[Positioned V	Vrong		_
	Г	Inspectio	n Strip in	Tube		Cut Too Short		Misread	i	Γ		Power Loss/	Surge	L	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

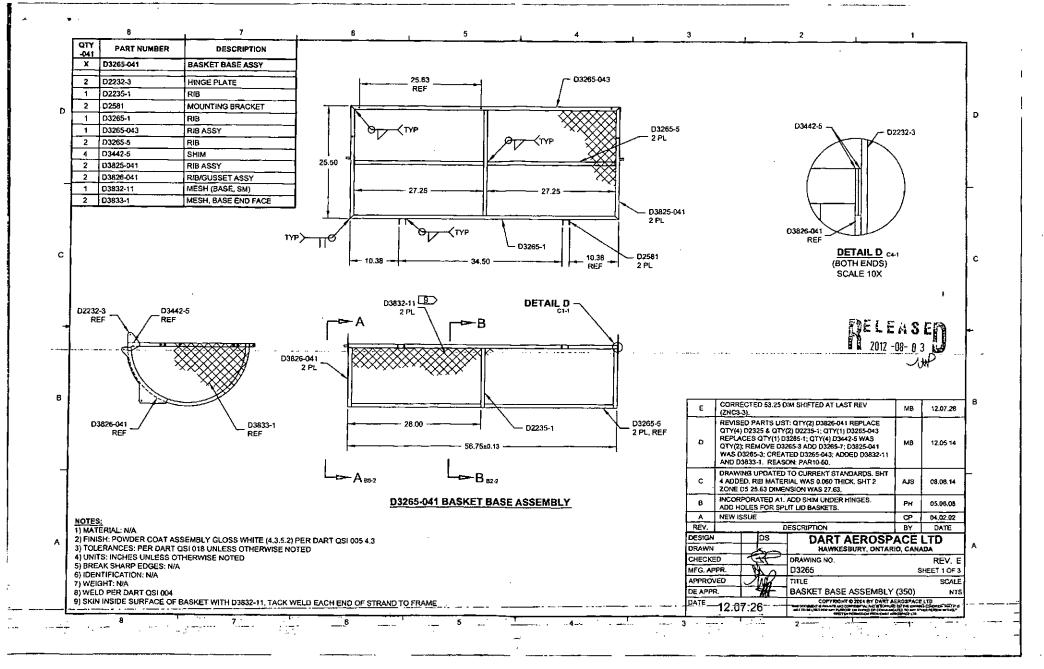
Torque Waves in Extrusion

Drill Holes

Drawing

Finish

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105843 MC5-13-08-21

									DQA:	Date	'`
NCR: Y	es / No				WORK ORDER NON-C	ONFOR	MANCE / UP	DATE	QA Closed:	Date	
_					DISPOSITION			AGAINST DE			
Work Orde	r:				Rework		Skid-tube	Crosstube	7	Water Jet	Engineering
Part N	o	<u> </u>			Scrap Use-as-is	Ther	Machining moforming	Small Fab Finishing	-1	d. Eng. Coor. re/Packaging	Quality
NCR N	lo				Work Order Update		Large Fab	Composite]	Supplier	
Root				Descri	ption of work order update	Initial	Ac	tion	Sign &		
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]	Bending				Bend	Grain		<u> </u>	Ovalized	ļ. <u></u>	Pressure/Forced
į	Centre Not Concentric to O/S				BOM/Route	Hardw		<u> </u>	Over/Under	·	Temperature/Cure
	Cracks				Broken/Damaged		tion Incomplete		Part Incorre	} —	Weld
	Crushed/	Crimped			Burrs	\vdash	tions Incomplete/	'Unclear	Part Lost/Mi		Wrong Stock Pulled
	Cuffs				Contamination	Maint	enance	<u> </u>	Part Moved		
	Heat Trea	it			Countersink	Mislab	eled		Positioned V		_
	inspectio	n Strip in	Tube		Cut Too Short	Misread			Power Loss/	Surge	Other
[Ripples in	Bend			Drill Holes	Offset					

Out of Calibration

Out of Sequence

Outside Dimensions

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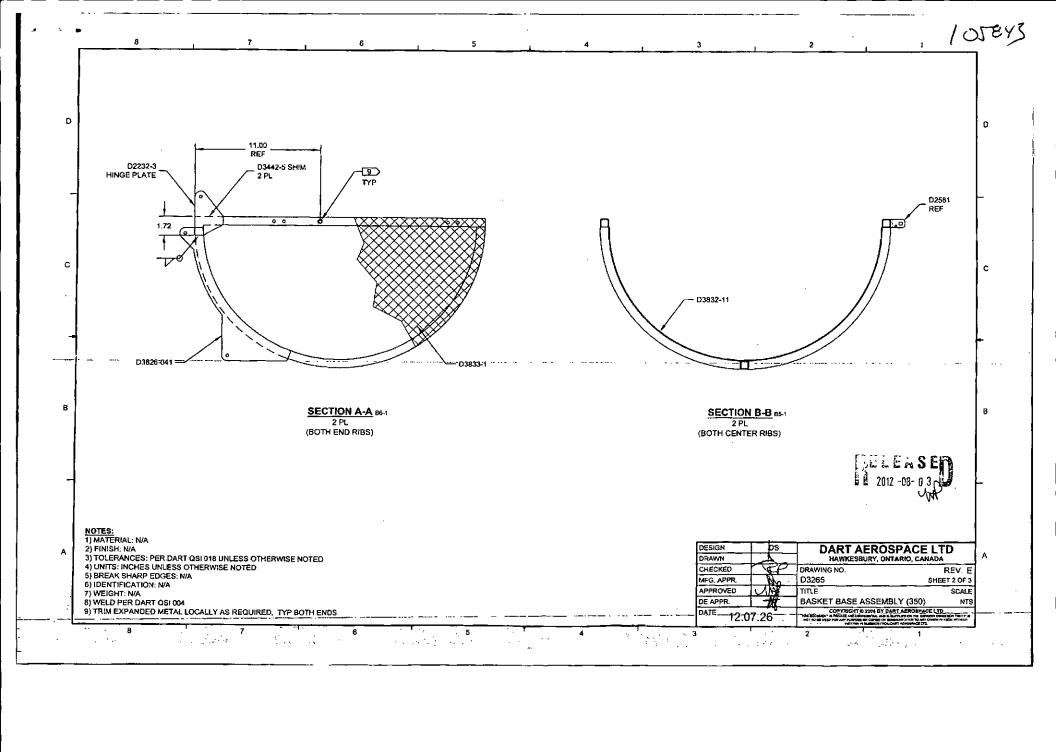
Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish



												DQA:	Da	ate:	
NCR:	/es	/ No				WORK ORDER NON-	coi	NFORM	/ANCE / UP	DATE					
												QA Closed:	Da	ite:	
Work Orde	or.					DISPOSITION				AGAINST	DE	PARTMENT,	/PROCESS		
Part NCR I	- ۱۰۰					Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	-	4	Water Jet d. Eng. Coor re/Packaging Supplier		Engineering Quality Other
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Cause	-	Date	Step	Qty		or Non-conformance	10	nief Eng	Desc	ription		Date	vernicatio	<i>)</i> (1	QC mspector
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							AUI	LT CATE	JORY			••	 		<u> </u>
Landi		1			- -	General]_ ·			i—	۱			1
	<u> </u>	Bending				Bend	\vdash	Grain			⊢	Ovalized		\vdash	Pressure/Forced
		Centre N	ot Conce	ntric to	^{D/S}	BOM/Route	_	Hardwa			┝	Over/Under		-	Temperature/Cure
		Cracks				Broken/Damaged	\vdash	-i `	on incomplete		L	Part incorre			Weld
E		Crushed/	Crimped		<u> </u>	Burrs	\vdash	₹	ions Incomplete/	'Unclear	L	Part Lost/Mi	issing		Wrong Stock Pulled
	L_	Cuffs			<u> </u>	Contamination	\perp	Mainte			L	Part Moved			
	<u> </u>	Heat Trea			<u> </u> _	Countersink		Mislabe			_	Positioned V	=		7
	辶	Inspectio	n Strip in	Tube		Cut Too Short	L	Misread	l		L	Power Loss/	Surge	L	Other
J	1	Ripples in	n Bend		1	Drill Holes	1	Offset							

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

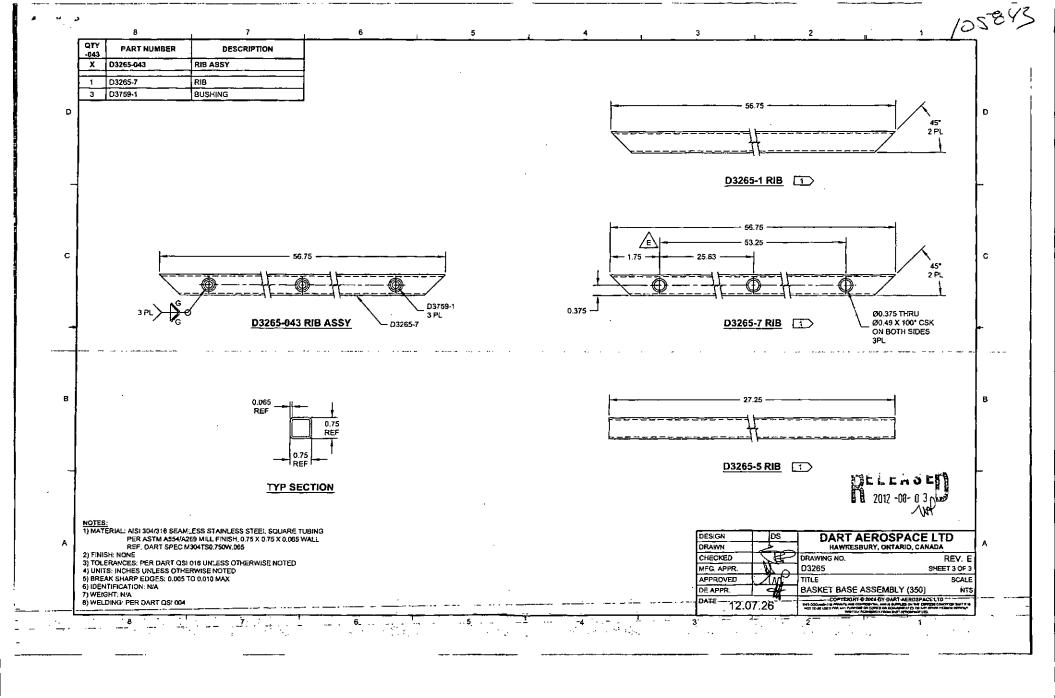
Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

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NCR:	⁄es	/ No				WORK ORDER NON-	COI	NFORM	MANCE / UPDA	ATE				
		•				_					QA Closed:	Da	ate:	
Work Orde	er:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS		
Part I	-					Rework Skid-tube Crosstube Scrap Machining Small Fab Use-as-is Thermoforming Finishing Work Order Update Large Fab Composite					Pro Rec/Stor	Engineering Quality Other		
Root	Ī	· · · · · · · · · · · · · · · · · · ·			Descri	ption of work order update		Initial	Actio	n	Sign &			
Cause		Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Descrip	tion	Date	Verification	on	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved	p/Tooling rator erial up er erss plier ning						FAUI	LT CATE	GORY					
Landi	ng G	iear				General				·	_			
Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend						Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		4	on Incomplete ions Incomplete/Und nance led	clear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	et ssing Vrong		Pressure/Forced Femperature/Cure Weld Wrong Stock Pulled Other
		Torque W	aves in F	xtrusio	, [Drawing	1	Out of C	alibration					

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish Folio

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